

Work Order ID 85911

June-18-12 2:30:23 PM

85911

Page 1

Item ID: D3499-3

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plastic Cable Guard

Start Date: 18/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3499

Rev C

100

100

Waterjet

FLOW CNC Waterjet

UHM W 6055

FLOW WATER JET

Memo

1-Cut as per Dwg D3499

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

SCRAP

Scrap

~~RS126-20~~
PTO →

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

~~RS126-20~~

120

120

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA636 Rev: AA & Dwg-D3499 Rev: C

2-Deburr per dwg D3499

0.00

0.00

12/10/21

W/O: 85911		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3499-3 PAR #: _____ Fault Category: Water Jet NCR: Yes No QQA: 2/11/24 Date: 12/11/24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11

NCR: 12-7048		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-11-14	100	Holes out of tolerance on all six parts	<u>[Signature]</u> 03/11/24	Scrap & Replace			<u>[Signature]</u> 03/11/24	<u>[Signature]</u> 12-11-14

\$136.92
x 6
\$821.52

NOTE: Date & initial all entries

June-18-12 2:30:23 PM

85911

Page 2

Item ID: D3499-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plastic Cable Guard

Stop *NS2*

Start Date: 18/06/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 02/07/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC Memo

0.00

Quality Control

140	0.00
-----	------

140

CONVENTIONAL MILLING MACHINE

Mill Conv	Memo
1	1
2	2
3	3
4	4
5	5
6	6
7	7
8	8
9	9
10	10
11	11
12	12
13	13
14	14
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94	94
95	95
96	96
97	97
98	98
99	99
100	100

0.00

Conventional Milling Machine C'BORE AS PER DWG D3499

150	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85911

June-18-12 2:30:23 PM

85911

Page 3

Item ID: D3499-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plastic Cable Guard

Start Date: 18/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

U12.11.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-18-12 2:30:26 PM

Page 1

Work Order ID: 85911

85911

Parent Item: D3499-3

D3499-3

Parent Item Name: Plastic Cable Guard

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 06-05-05 JLM

IPP Rev:B As per Rev B 06-08-31 JLM

revC DD 10.02.23 verified by:EC

IPP Rev:C as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB625		Purchased	No			110	sf	19.0000	1.081	6.827368			

MUHMWB625

UHMW .625 Black Tivar 1000

**

BCL-6-28

Location

Loc Qty

Loc Code

MAT019

19

119591

19

119591

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	85911
Description: Cable Guard		Part Number:	D3499-3
Inspection Dwg: D3499	Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:		Audited by:		Preliminary Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.27	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	

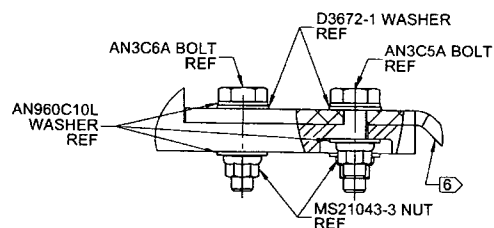
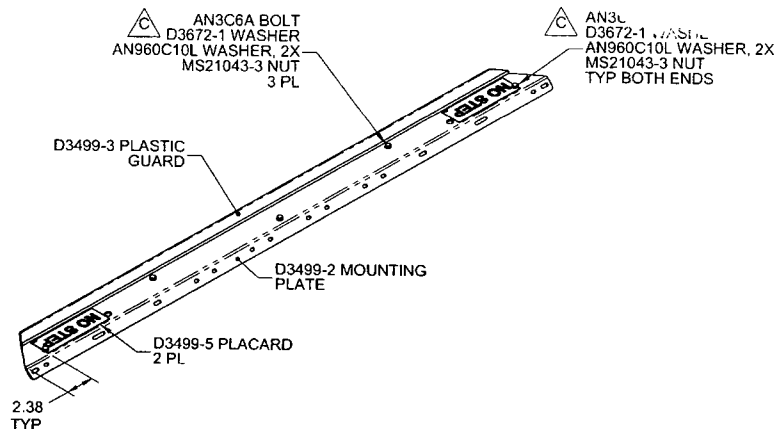
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

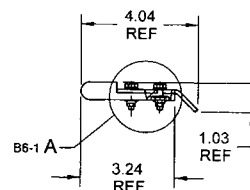
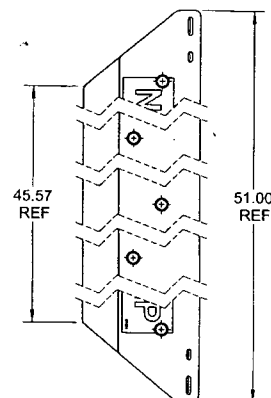
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A
SCALE 4X



D3499-042 CABLE GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3499-041/-042" USING F.
- 7) WEIGHT: 3.90 lbs

PERMANENT INK MARKER

ITEM	QTY	P/N	DESCRIPTION
1	X	D3499-042	CABLE GUARD ASSEMBLY
2	1	D3499-2	MOUNTING PLATE
3	1	D3499-3	PLASTIC GUARD
4	2	D3499-5	PLACARD
5	2	AN3C5A	BOLT
6	3	AN3C6A	BOLT
7	10	AN960C10L	WASHER
8	5	MS21043-3	NUT
9	5	D3672-1	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85911 MCT
12/06/10

RELEASED
2010-02-02
MD

C	DRAWING UPDATED TO CURRENT STANDARDS. 3.24 WAS 3.25 (ZN B6-3); 3.24 WAS 3.25 (ZN D3-3); REVISE TOLERANCE & 2.01 WAS 2.00 (ZN D3-3); D3672-1 WAS NAS1515H3L (ZN D3-1, D5-1, D7-1); ADD IDENTIFY NOTE (ZN A6-1); REF NCR-09-045	RF	09.06.19
B	RE-DESIGN D3499-2F/-3	MB	06.08.15
A	NEW ISSUE	MB	06.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO. D3499	REV. C	
MFG. APPR.		SHEET 1 OF 4	
APPROVED	TITLE	SCALE	
DE APPR.	CABLE GUARD	NTS	
DATE	09.06.19		

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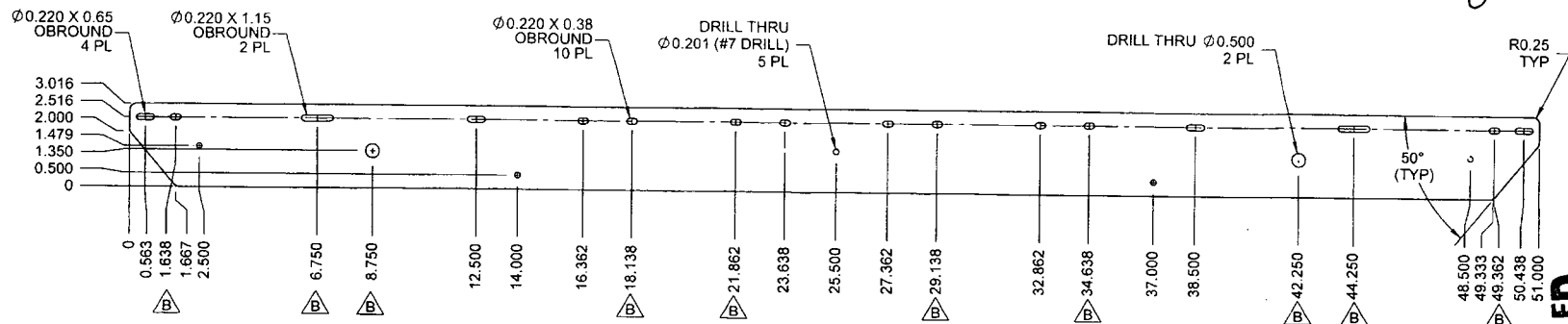
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

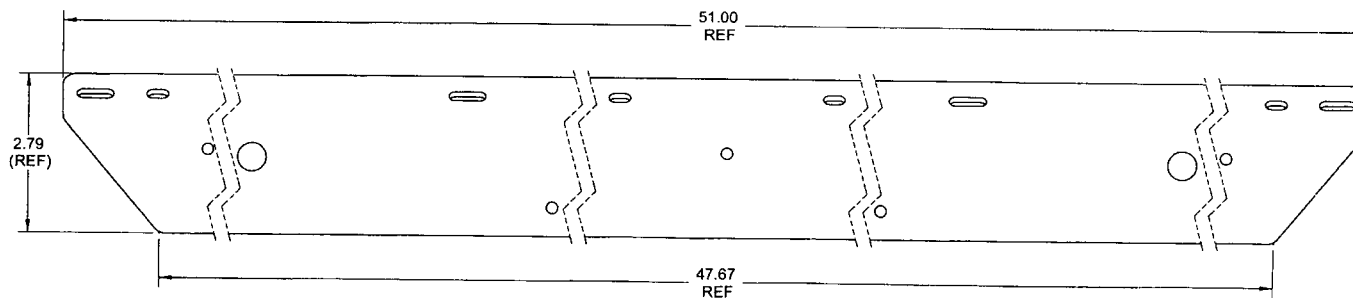
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

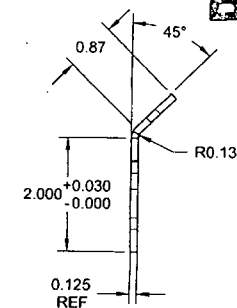
NOTE: Date & initial all entries



D3499-2F MOUNTING PLATE FLAT PATTERN
SCALE 0.5X



D3499-2 MOUNTING PLATE



D3499-2 BENDING DETAIL

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3499	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CABLE GUARD	NTS
DATE	09.06.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.	
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RELEASED
R 2010-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries